

**Work Order ID 61817**

Tuesday, September 07, 2010 12:38:54 PM

Page 1

Item ID: D206-581-014

Accept

Revision ID:

Item Name: Pre-Flight Step Installation, RH

Start Date: 9/7/2010 Start Qty: 6.00

Required Date: 10/13/2010 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D206-581

C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile &amp; type labels per PPPD206-581-014

CHG001

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

8/12/13

10/12/13sf

TS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 61817**

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Item ID: D206-581-014

Accept

Setup Start

Revision ID:

Stop

Item Name: Pre-Flight Step Installation, RH

Start Date: 9/7/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 10/13/2010 Req'd Qty: 6.00



Customer:



Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	<b>Memo</b>	0.00							
Packaging	Identify and pack for shipping as per PPP D206-581-013 Location: <u>32</u> PPP Rev: <u>A</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	<b>Memo</b>	0.00							
Quality Control									

10/12/13 10/12/14 

MF

10-12-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 61817

Parent Item: D206-581-014

Parent Item Name: Pre-Flight Step Installation, RH

Start Date: 9/7/2010

Required Date: 10/13/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 10-08-30 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
S 45 D4101-041- Pre-Flight Step Assembly		Manufactured	No				Each	0.0000	1	6		10/12/13	
S 45 D4102-2 Shim		Manufactured	No				Each	1.0000	1	6		10/12/13	
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				Eagle			1						
					61095		1						
S 45 80-005-3-16 INSERT		Purchased	No				Each	20.0000	6	36		10/12/13	
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				rus			20						
					115322		20						
S 45 MS27039-4-14 Screw		Purchased	No				Each	48.0000	6	36		10/12/13	
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST293			48						
					112273		48						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 2

Tuesday, September 07, 2010 12:39:00 PM

Work Order ID: 61817

Parent Item: D206-581-014

Parent Item Name: Pre-Flight Step Installation, RH

Start Date: 9/7/2010

Required Date: 10/13/2010

Start Qty: 6.00

Required Qty: 6.00

NAS1149D0416J

Purchased

No

Each

455.0000

6

36



Washer



10/12/13

(5x)

Location

Loc Qty

Loc Code

ST298

455

110153

2

114103

50

~~114884~~

200

~~115107~~

164

13910

39

11x  
19x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

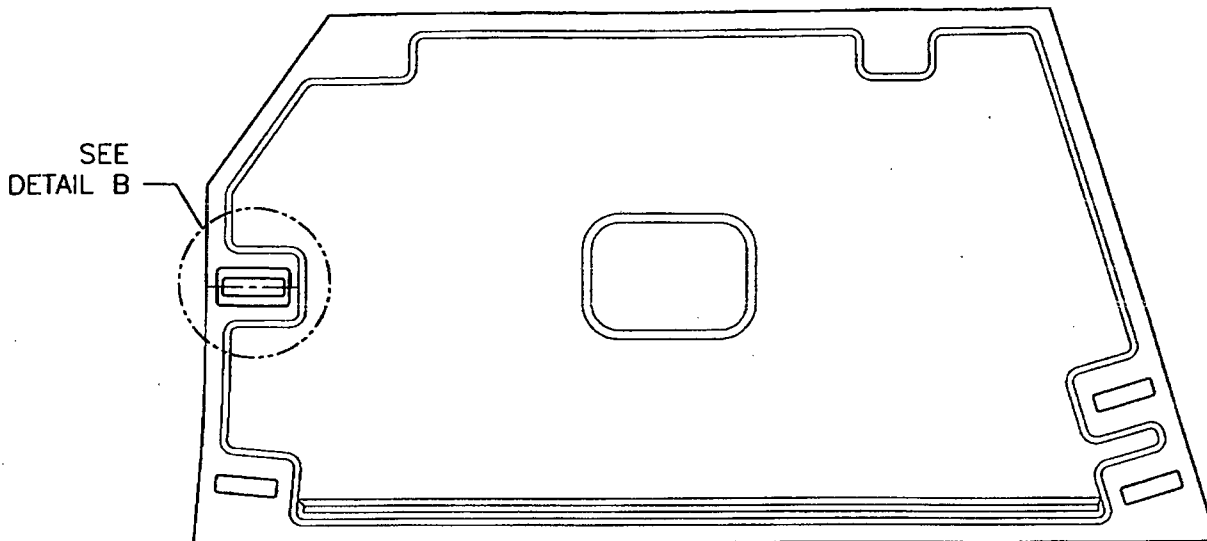
**NOTE:** Date & initial all entries



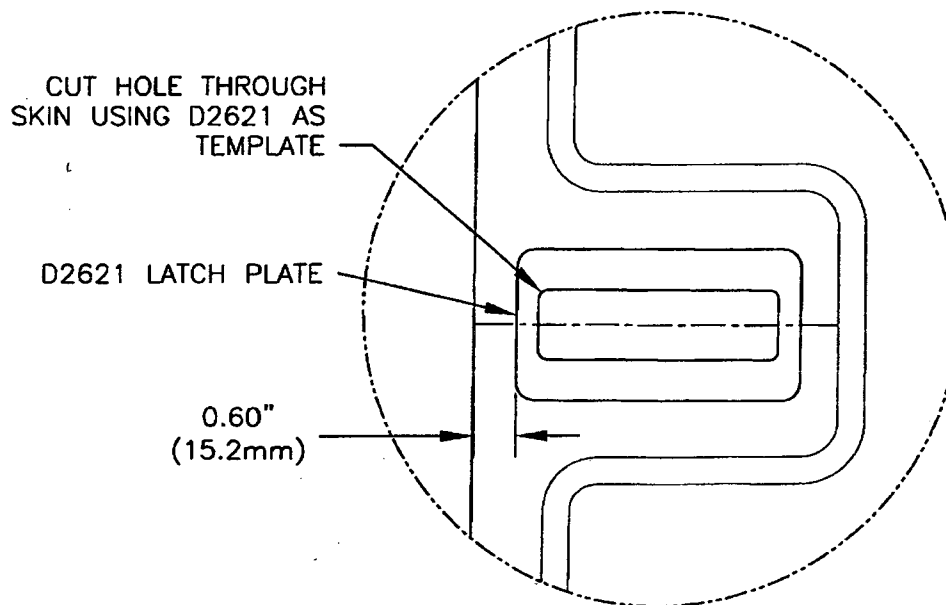
## 5.0 PART LIST

## 5.1 D407-581-111/-011 AND D206-581-113/-013/-014/-015/-017 KITS

Qty -111	Qty -113	Qty -011	Qty -013	Qty -014	Qty -015	Qty -017	Part Number	Description
X							D407-581-111	PRE-FLIGHT KIT (407)
	X						D206-581-113	PRE-FLIGHT KIT (206A/B/L/L1/L3/L4)
2		X					D407-581-011	PRE-FLIGHT STEP KIT, LH/RH (407)
	1		X				D206-581-013	PRE-FLIGHT STEP KIT, LH (206A/B/L/L1/L3/L4)
	1			X			D206-581-014	PRE-FLIGHT STEP KIT, RH (206A/B/L/L1/L3/L4)
4	4				X		D206-581-015	STEP HANDLE KIT
						X	D206-581-017	RETENTION STRAP KIT
						2	D3031-3	LOOP
		1	1	1			D4101-041	PRE-FLIGHT STEP ASSEMBLY
			1				D4102-1	SHIM (206 LH)
				1			D4102-2	SHIM (206 RH)
		1					D4102-3	SHIM (407)
					1		D4103-1	STEP HANDLE
						1	D4104-041	DOUBLER ASSEMBLY
						1	D4105-1	STRAP
						2	80-004-2D8	INSERT
					2		80-005-3-8	INSERT
		6	6	6			80-005-3-16	INSERT
						8	CR3243-4-1	RIVET
						2	MS21042L3	NUT
						2	MS24694-S47	SCREW
						2	MS24694-S50	SCREW
						2	MS24694-S52	SCREW
					2		MS27039-4-11	SCREW
		6	6	6			MS27039-4-14	SCREW
						2	NAS1149D0332J	WASHER (or AN960JD10L)
		6	6	6	2		NAS1149D0416J	WASHER (or AN960JD416L)
					2		NAS1149D0463J	WASHER (or AN960JD416)



**FIGURE 3: CUTTING LATCH HOLE**



*6/24/1*

**DETAIL B**

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

**APPROVED**

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 09.05.26  
CERT. NO.: SH92-41  
ISSUE NO.: 8

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	DSI 9463	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SIDE DOOR MODIFICATION	NTS
DATE	09.05.26	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

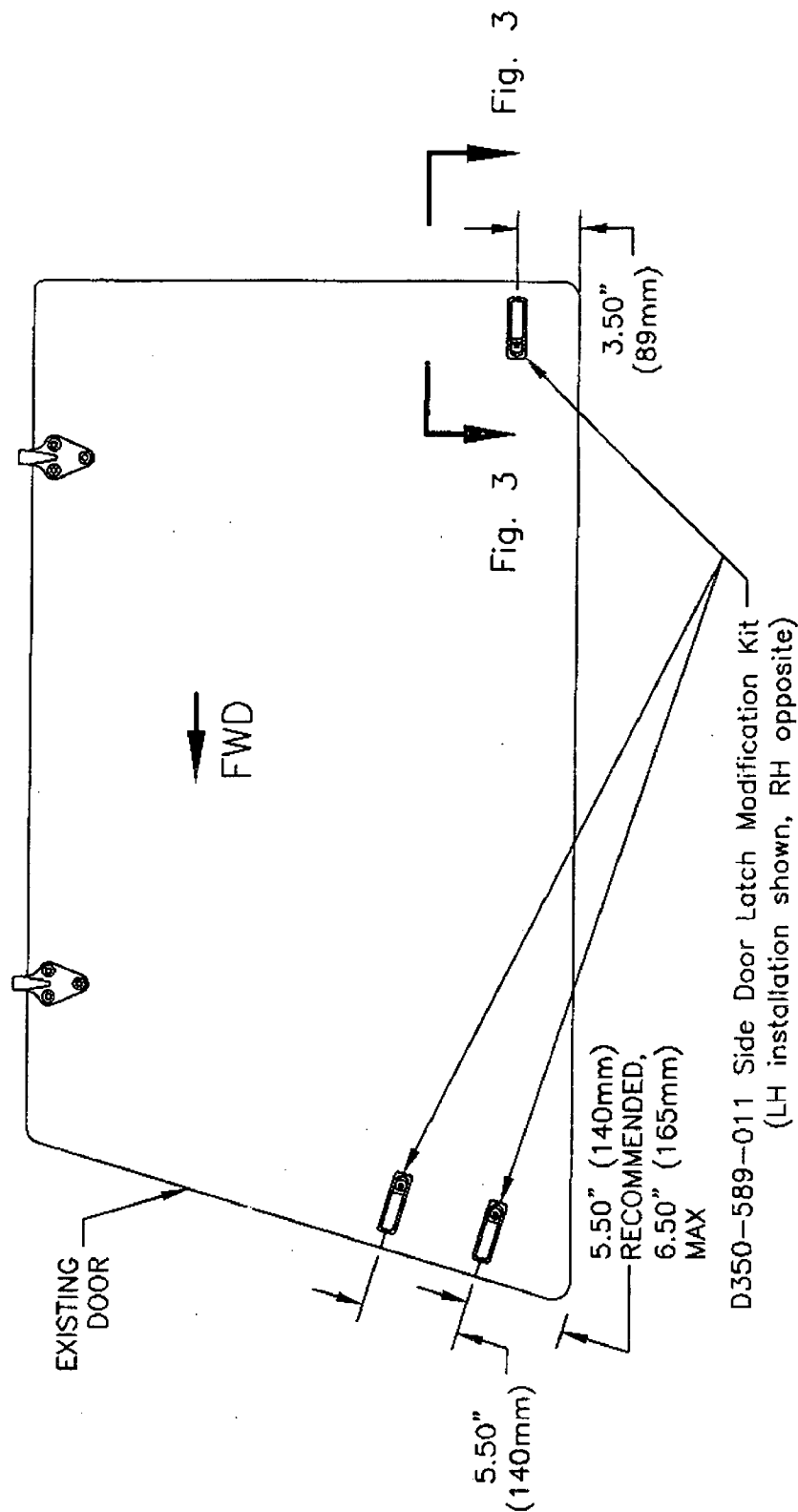


Figure 2: Typical D350-589-011 Side Door Latch Modification Kit

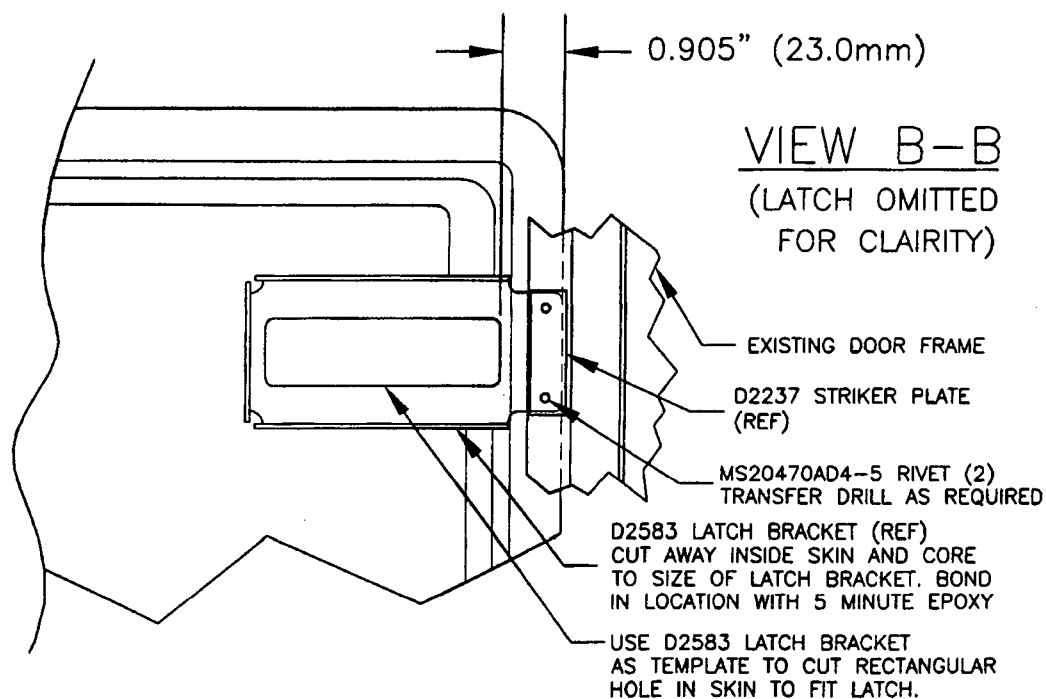
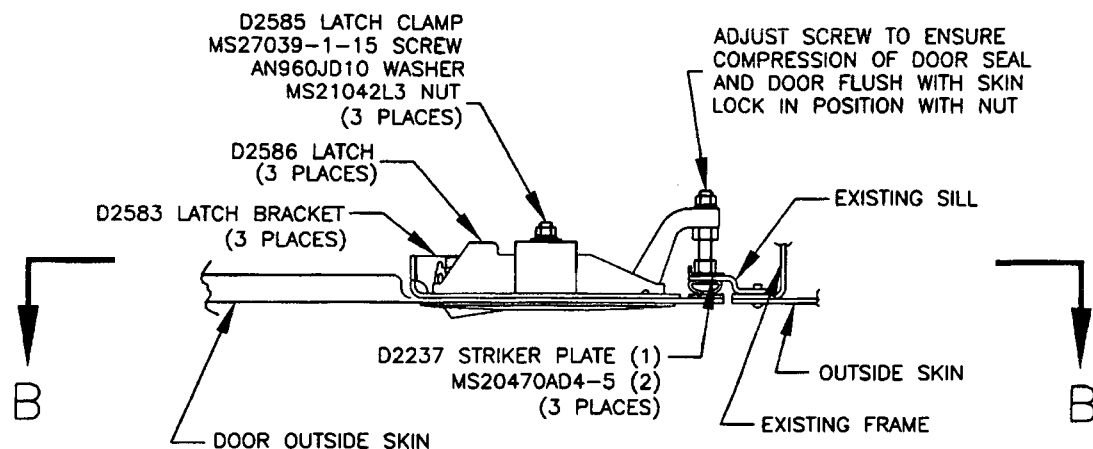


Figure 3: Typical Latch Bracket Installation